

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007567**Date Inspected:** 30-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER COMPONENTS**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Gady Rao, was present during the times noted above for observations relative to the work being performed.

**Magnetic Particle Testing:**

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) & the weld designations reviewed are as follows:

Bay 10

Inspection part	Section	Inspection Area.
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SSD1-FESA4-1F/F-7A/B; 13A/B; 21A/B; 28A/B	South Tower; Lift-4; Skin-E	Bay - 10
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Bay 10

SAW

1)SAW welding of weld joint NSD1-FESA4-3A/F-10B, 11B located on North Tower; Lift-4; Skin-E; skin to skin welds. Welder is identified as 209051. ZPMC QCI is identified as Shi Jing Wei. The welding variables recorded

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## WELDING INSPECTION REPORT

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by QC appeared to comply with the WPS- B-T-2221-B-U3C-S-2.

Bay 11

SAW–Strut connection plates.

1)SAW welding of weld joint SD1-A6002-12-4B; SD1-A6002-12-2A; SD1-A6002-11-4B; SD1-A6002-11-2A; SD1-A6002-13-2A located on South Tower. Welder is identified as 040772. ZPMC QCI is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS- B-T-4221-B-U3C-S-1.

2)SAW welding of weld joint WD1-A6001-3-1A; WD1-A6001-2-3B; WD1-A6001-2-1A; WD1-A6001-1-3B; WD1-A6001-1-1A located on West Tower. Welder is identified as 042195. ZPMC QCI is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS- B-T-4221-B-U3C-S-1.

FCAW

1)FCAW welding of weld joint WSD1-FASA4-2E/E-94A, 61A; located on West Tower; Lift-4; Skin-A. Welder is identified as 066421. ZPMC QCI is identified as Tao Lu Hai. The welding variables recorded by QC appeared to comply with the WPS- B-T-4231-B-U3-F.

2)FCAW welding of welds joint WSD1-FDSA4-4D/D-51B located on West Tower; Lift-4; Skin-D; Stiffener to stiffener welds. Welder is identified as 070251. ZPMC QCI is identified as Tao Lu Hai. The welding variables recorded by QC appeared to comply with the WPS- B-T-4231-B-U3-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Rao,Gady	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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